

Work Order ID 61140

Monday, August 09, 2010 1:59:40 PM



Page 1

Item ID: D3319-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearplate

Start Date: 8/10/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 8/31/2010 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: MF

Date: 10-8-9 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3319

Rev B

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3319

☐ Dwg Rev: B

☐ Prog Rev: B

☐ 2-

Debur if necessary

1010 - 050

B 10-8-11



110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B 10-8-11

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

5.10/08/11



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130



Small Fab

Small Fab

Small Fab

Memo

Debur if necessary

0.00

0.00

140



Brake NC

Brake NC

NC BRAKE

Memo

Form using DT8326 & DT8261 as per Dwg D3319Rev: _____

0.00

0.00

150



QC

Quality Control

QC6- Inspect dimensions to drawing

Memo

0.00

0.00

8/30/08/19 (9)

(49)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item Name: Wearplate

Start Date: 8/10/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 8/31/2010 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

160

0.00



Large Fab

Large Fab

Memo

0.00

Weld hard surface using D3319-3T2 per QSI 004 and Dwg D3319 Rev:

Qty	Part Number	Description	Batch	A/R
N/A	7560 Hardcoat Rod	4 112507		

Large Fab

10/10/21 (94)

170

0.00



QC10- Inspect visual per QSI004- ground welds

QC

Memo

0.00

Quality Control

9 10/10/21

180

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

9 10/10/21

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Item ID: D3319-3

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Revision ID:

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Item Name: Wearplate

Start Date: 8/10/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 8/31/2010 Req'd Qty: 12.00

Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190



Powdercoat

Powder Coating

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

6/10-10-22

9

M112588

Memo

0.00

START TIME:

7:40

OVEN TEMPERATURE:

320° FINISH TIME:

3:10

200



QC

Quality Control

QC3- Inspect Part Finish

0.00

7/10/10/22

9

Memo

0.00

210



Packaging

Packaging

Packaging

0.00

0.00

Memo

Identify on inside surface using a permanent fine point marker with the following: TCCA-PDA, Dart Aerospace Ltd. P/N: D3319-3, B/N: BXXXXX For Product Eligibility see PDA05-18 and Stock Location: 187

10/10/22 90

Work Order ID 61140

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Item ID: D3319-3

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Item Name: Wearplate

Start Date: 8/10/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 8/31/2010 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

220

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/10/22

MF
10-10-22

Picklist Print

Monday, August 09, 2010 1:59:40 PM

Page 1

Work Order ID: 61140



Parent Item: D3319-3



Parent Item Name: Wearplate



Start Date: 8/10/2010

Required Date: 8/31/2010

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP: A ☐ 05.05.12 ☐ New issue ☐ KJ/JLM ☐
IPP Rev: B Now on Waterjet 06-10-03 JLM ☐

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M1010S18GA 		Purchased		No		100	sf	40.4585	3.2524	41.08295		30.	
1010/1025 SHEET .048												10-8-11	

Location

Loc Qty

Loc Code

MAT19

40.45853

114225

40.45853

114225

9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	61140
Description: Wearplate		Part Number:	D3319-3
Inspection Dwg: D3319 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

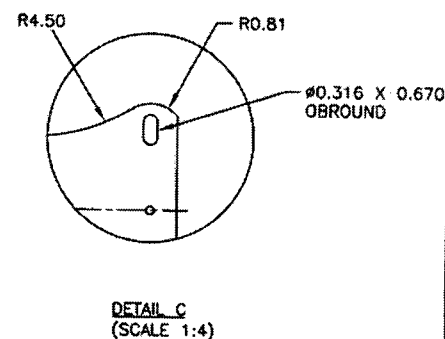
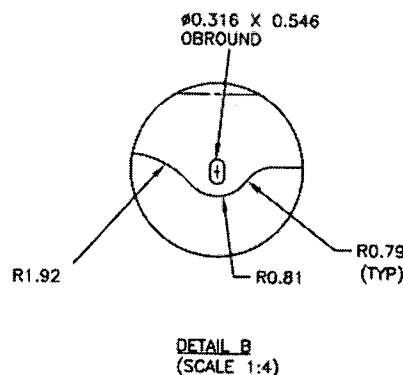
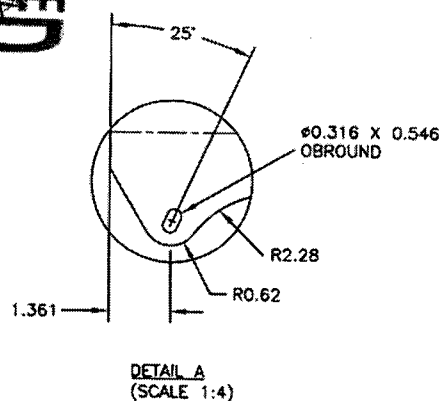
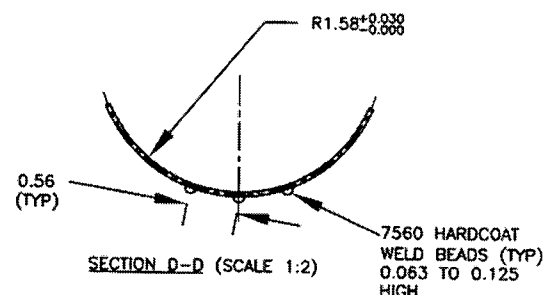
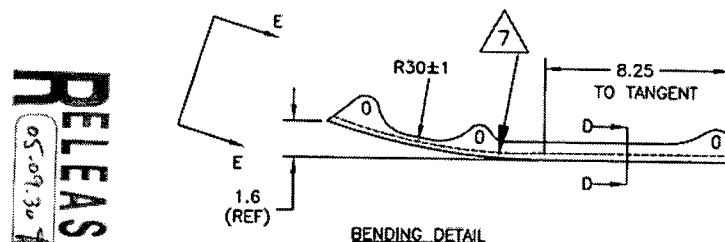
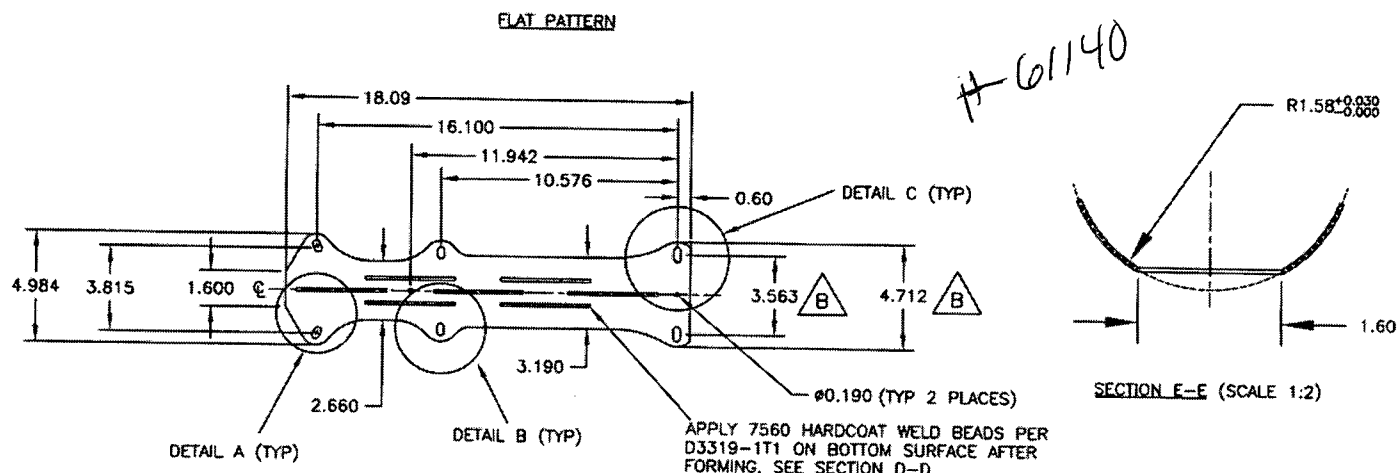
☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
75.52	+/-0.030	75.52	X		T 1801	
74.420	+/-0.010	74.420	X		T	
62.770	+/-0.010	62.770	X		T	
52.890	+/-0.010	52.890	X		T	
30.790	+/-0.010	30.790	X		T	
8.690	+/-0.010	8.690	X		T	
0.60	+/-0.030	.600	X		V 1802	
2.690	+/-0.010	2.696	X		V	
2.940	+/-0.010	2.940	X		V	
3.527	+/-0.010	3.529	X		V	
4.518	+/-0.010	4.516	X		V	
Ø0.190	+0.005/-0.001	.192	X		V	
2.940	+/-0.010	2.947	X		V	
2.940	+/-0.010	2.946	X		V	
2.690	+/-0.010	2.696	X		V	
5.063	+/-0.010	5.061	X		V	
6.163	+/-0.010	6.164	X		V	
Ø0.316 x 0.607	+0.006/-0.001 x +/-0.010	316x609	X		V	
0.048	+/-0.010	.047	X		V	

Measured by: RB	Audited by: S	Prototype Approval:	N/A
Date: 10-8-11	Date: 10/09/11	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.07.18	New Issue	KJ/JLM	BE

DART

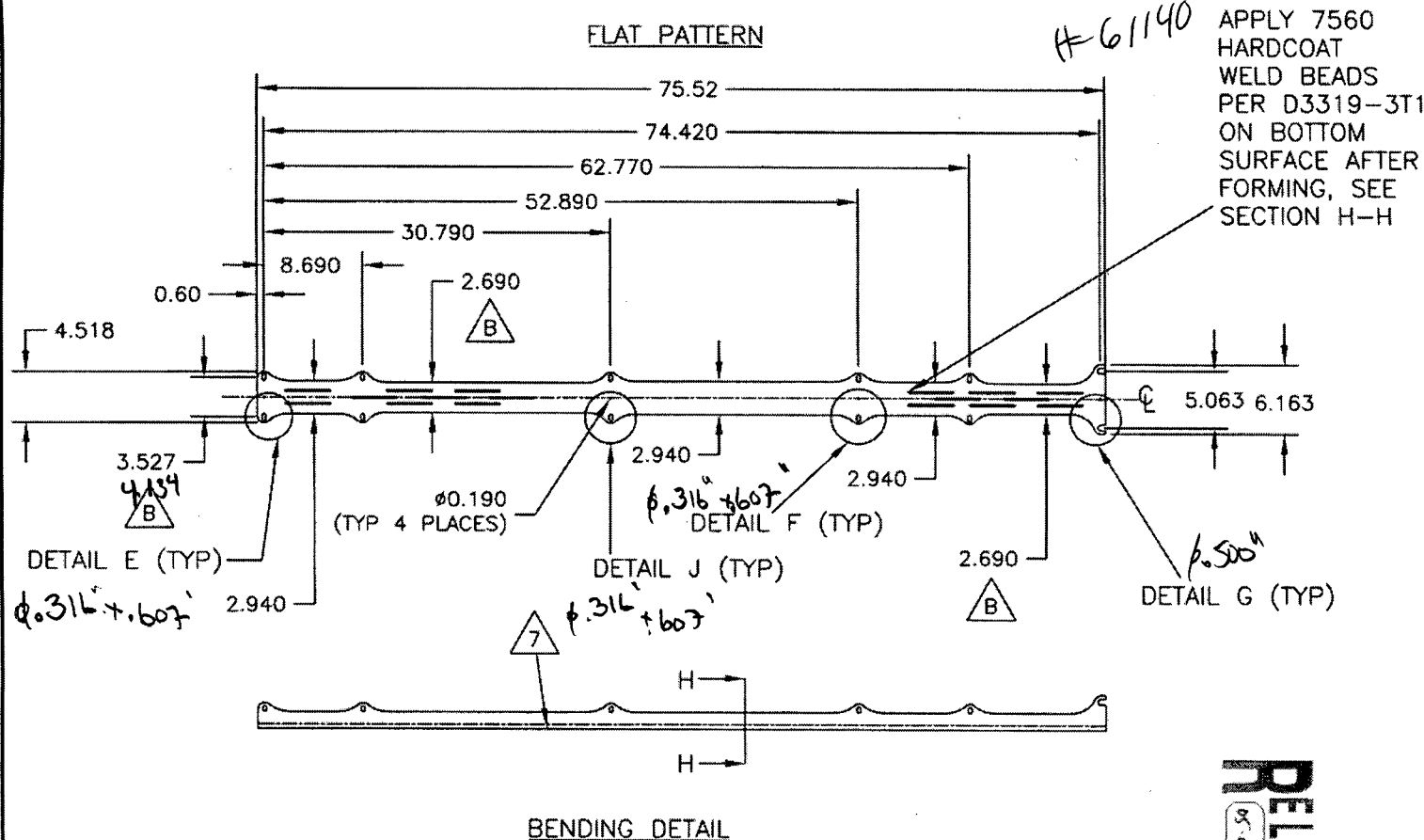


D3319-1 WEARPLATE

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA C40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-1 B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-18"

DESIGN	DRAWN BY	DART AEROSPACE LTD
41	41	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
		D3319
DATE	TITLE	SHEET 1 OF 5
05.06.06	WEARPLATE	SCALE 1:8
A	NEW ISSUE	
04.09.24		
B	WIDEN HOLES, REDUCE WIDTH -3/-5/-7	
05.06.06		

RELEASED
05-09-30



DART

DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA
DATE	DRAWING NO.	REV. B
05.06.06	D3319	SHEET 2 OF 5
	TITLE	SCALE
	WEARPLATE	1:15

D3319-3 WEARPLATE

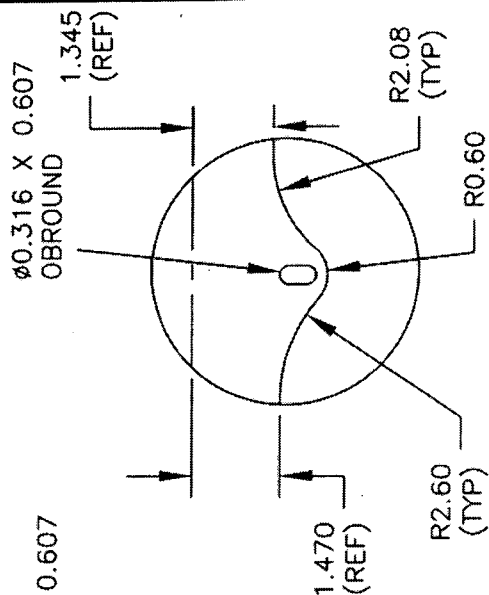
- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-3 B/N BXXXXX,
FOR PRODUCT ELIGIBILITY SEE PDA05-18"



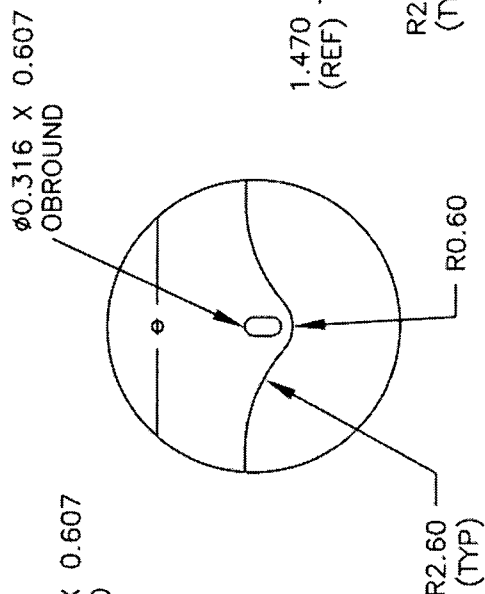
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CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3319	REV. B SHEET 5 OF 5
DATE 05.06.06	TITLE WEARPLATE		SCALE 1:3

RELEASED
05.09.30

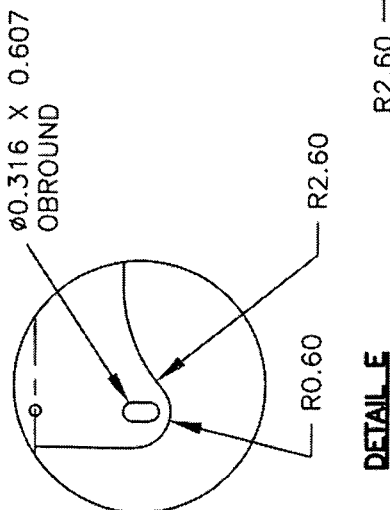
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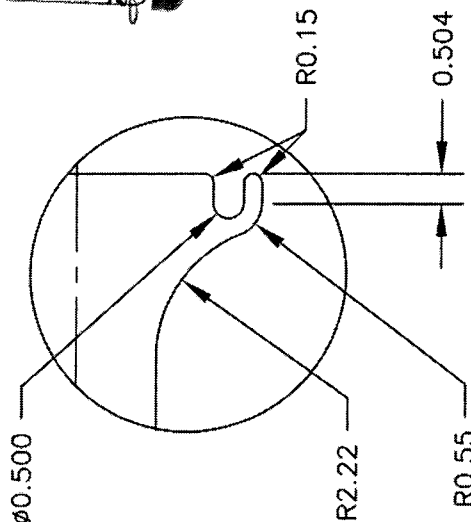
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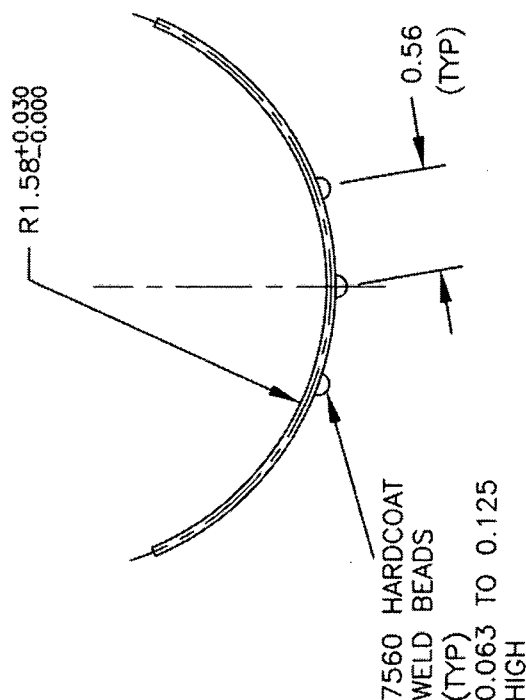
DETAIL F



DETAIL E



DETAIL G



SECTION H-H
(SCALE 1:1)

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